

Del R. 1.000

Work Order ID 85864

85864

Page 1

June-18-12 10:50:15 AM

Item ID: D2054

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Bushing

Start Date: 15/06/2012 Start Qty: 20.00

20

Cust Item ID:

Required Date: 02/07/2012 Req'd Qty: 20.00

20

Customer:

Reference:

Approvals:

Process Plan: MLJ

Date: 12/06/18

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D2054	Rev B								
100		0.00							
100	Hardinge CNC LATHE SMALL								
Hardinge	Memo	0.00		<u>12/12/14</u>		<u>20</u>	<u>0</u>		
Hardinge CNC Lathe Small	Machine as per folio FA Deburr								
110	QC2- Inspect parts off machine FAI/FAIB	0.00							
110									
QC	Memo	0.00		<u>12/12/14</u>		<u>20</u>	<u>0</u>		
Quality Control									
120	QC8- Inspect parts - second check	0.00							
120									
QC	Memo	0.00		<u>12.12.15</u>		<u>20</u>	<u>4</u>		
Quality Control									

DAS
04
9-89

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Page 2

0.00

MCJ 12-72-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

June-18-12 10:50:19 AM

Page 1

Work Order ID: 85864

85864

Parent Item: D2054

D2054

Parent Item Name: Bushing

Start Date: 15/06/2012

Required Date: 02/07/2012

Start Qty: 20.00

Required Qty: 20.00

Comments: IPP A1 03.01.21 Revise Dwg Rev B; added Black Teflon or Delring: Made on Cobra RF

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MDELRINR1.000		Purchased	No			120	f	23.3202	0.0583	1.227368			
MDFI RINR1 000									**	1.333'		<i>12/12/12</i>	
Delrin Round Bar 1"													

Location

Loc Qty

Loc Code

MAT055

23.3202

117985

0.407

118392

6.2762

119306

16.637

122.582

1.333'

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

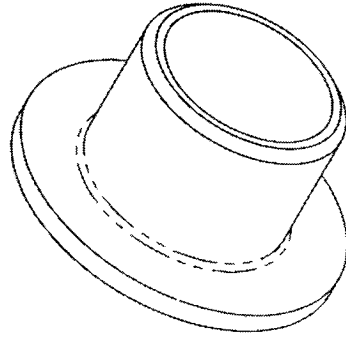
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



RELEASED
01.12.21

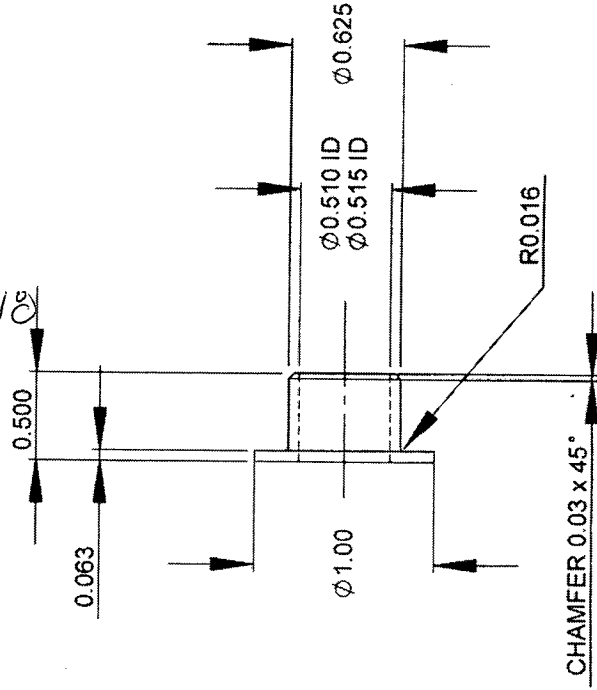
DESIGN	JB	DRAWN BY	LP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	[Signature]	APPROVED	[Signature]	DRAWING NO.	REV. B
DATE	01.12.20	TITLE		D2054	SHEET 1 OF 1
		BUSHING		SCALE	
--		NEW ISSUE		1:1	
A		CHANGE TOL. ON ID.			
B		REDRAW; ADD DELRIN OPTION; ADD NOTES			



ISOMETRIC DETAIL (SCALE 2:1)

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 85864 MLS

12/06/18



D2054 BUSHING

MATERIAL: BLACK TEFLON
or BLACK UHMW
or BLACK DELRIN

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
ALL DIMENSIONS ARE IN INCHES

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